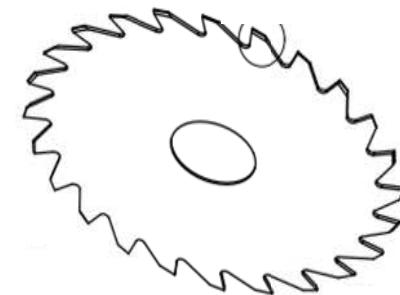


## Carbide Saw Blades Ø42 Z24, W 0.37mm

### A04-200

The resharpening of a pack of circular sawblades mounted on an arbor with material removal of 0.2 mm on cutting face and OD and polished surfaces can be done as shown below with a pregrinding and polishing process for each surface. Polishing is executed with a grain D20, removing 0.03 per pass. If only polishing wheels are used, then 5 to 6 passes are needed. The total grinding time would be 14 Min. With pregrinding and finishing total time is 8 Min.



### 1. Cycletime for Resharpening

Workpiece:	Pack of total length 22 mm Material CARBIDE				
Operations	Probe	Flute 1	Flute 2	O.D.2	O.D.1
Feed [mm/Min]	2000	300	800	300	800
Power [kW]		3	2	1	2
Cutting speed [m/s]		32	32	32	32
Used wheels		1	2	3	4
Grinding time [s]	9	184	73	175	70
Total cycle time	8 Min 31				

### 2. Used Grinding Wheels

In this application the cycle time per blade is important. Actually we used a package of 60 saw blades. So the cycle time per blade is 8.5 seconds.

1	12V9 Ø50 D64
2	12V9 Ø50 D20
3	11V9 Ø75 D64
4	11V9 Ø75 D20



3 1

2 4

### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : ARIES 5

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP. 21.1.13

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